

# Work Order ID 86933

**\*86933\***

Page 1

July-09-12 2:50:55 PM

Item ID: D3238-35 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Plate  
 Start Date: 7/09/12 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 8/10/12 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/10 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3238	Rev C								

100 0.00  
**\*100\*** FLOW WATER JET  
 Waterjet Memo 0.00 5 0 Jun 12-7-22  
 FLOW CNC Waterjet 1-Cut as per Dwg D3238 Dwg Rev: C Prog Rev: C 2-  
 Debur if necessary \*\*\*Use cutting file D3238-21-23-25\*\*\*\*\*  
6061 1020

110 0.00  
**\*110\*** QC2- Inspect parts off machine FAI/FAIB  
 QC Memo 0.00 5 0 Jun 12-7-22  
 Quality Control

120 0.00  
**\*120\*** QC8- Inspect parts - second check  
 QC Memo 0.00 5 0 Jun 12-7-22  
 Quality Control

SMB  
12-7-23

DAS  
16  
12/14/23

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*86933\***

July-09-12 2:50:55 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*5\***

**\*5\***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Date:**

Stop \*NR2\*

Date:

**Insp.  
Stamp**

**\*130\***

0,00

## Hand Finishing

0.00

\*140\*

0.00

## Quality Control

Identify as per dwg & Stock Location: 37

0.00

**\*150\***

0.00

## Packaging

12723

W/O:		WORK ORDER CHANGES					
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**\*86933\***

July-09-12 2:50:55 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*5\***

**\*5\***

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

mf  
12-07-24

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# Picklist Print

July-09-12 2:50:54 PM

Page 1

Work Order ID: 86933

Parent Item: D3238-35

Parent Item Name: Plate

Start Date: 7/09/12

Required Date: 8/10/12

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 07-01-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq IF	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.020  
6061-T6 Sheet.020

Purchased

No

100

sf

62.7360

0.024

~~0.126316~~

~~0.25~~

3m 12-7-22

Location

Loc Qty

Loc Code

MAT021

62.736

112442

14.736

119743

48

119743

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**Dart Aerospace Ltd**

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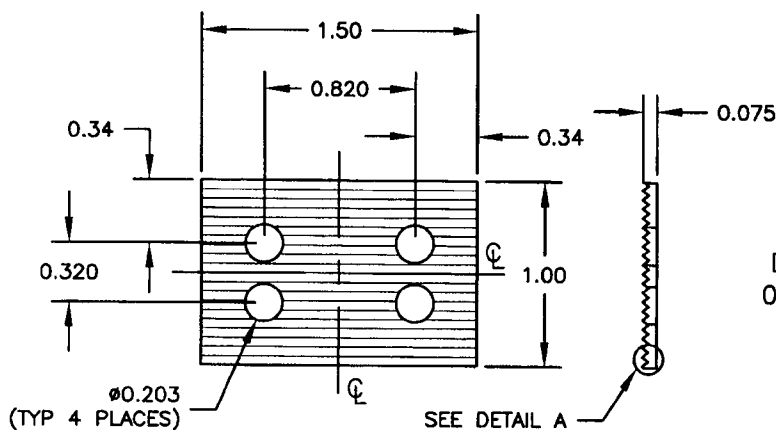
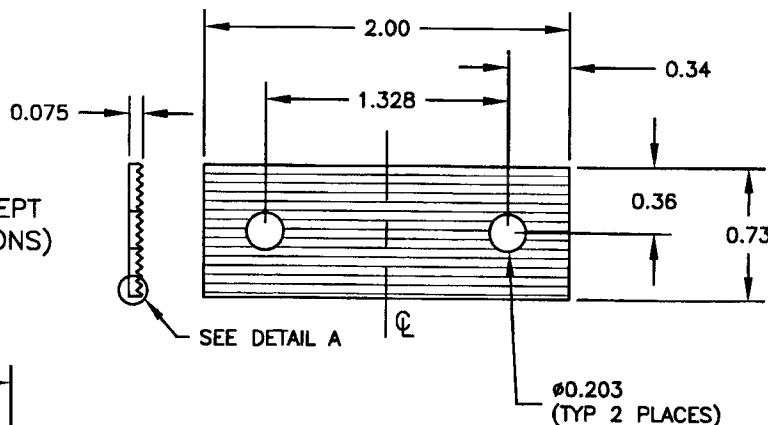
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

RELEASED

07.02.20

**D3238-1 PLATE (SHOWN)**

D3238-11 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



**D3238-3 PLATE (SHOWN)**

D3238-13 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

**NOTES:**

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:  
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037  
(REF DART SPEC M2024T3S)  
-11/-13/-15/-31/-33/-35 PLATE:  
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR  
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)  
OR  
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR  
AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT  $\phi$

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12/09/10  
06933 MJS  
WORK ORDER  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
RETURN TO  
ENGINEERING

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

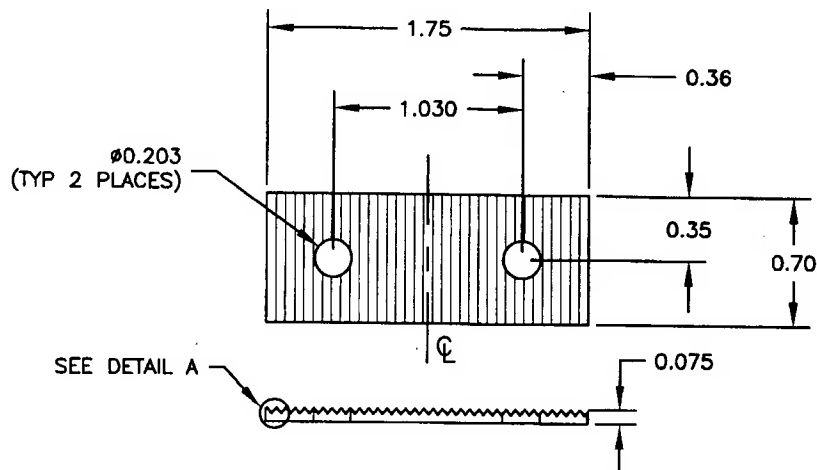
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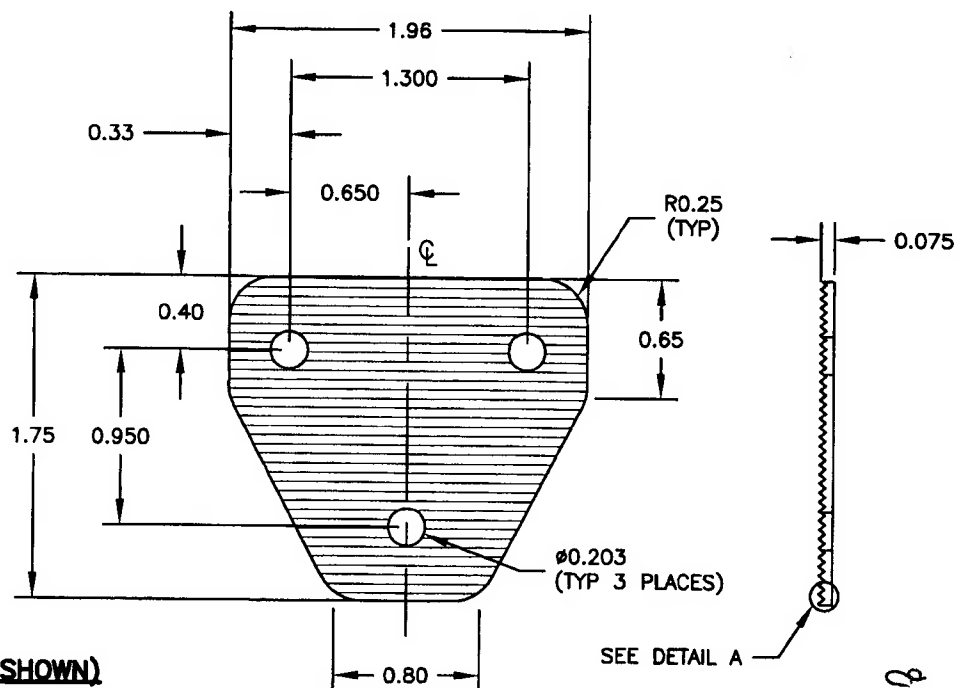


DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1



RELEASED  
07.02.20

**D3238-5 PLATE (SHOWN)**  
D3238-15 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)



**D3238-21 PLATE (SHOWN)**  
D3238-31 PLATE (SAME, EXCEPT  
0.020 THICK AND NO SERRATIONS)

86933

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